



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

May 7th
D5380-1

Job Sheet 176805



Part No: D5380-1

Job Qty: 6 ea *2 unit Split*

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/10/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV.A NEW ISSUE JFS 16/02/02 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		5/10/18	0.00	0.00	Start Up Machining-4		<i>llh</i>
100	CNC Vertical Machining	6 pcs		5/10/18	0.73	20.69	HAAS1-2		<i>llh</i>
110	QC	6 pcs		5/10/18	0.00	0.00	QC2 Machining-4		<i>llh</i>
120	QC	6 pcs		5/10/18	0.00	0.00	QC8 Machining-4		<i>llh</i>
121	QC	6 pcs		5/10/18	0.00	0.00	QC5		<i>llh</i>
130	Packaging	6 pcs		5/10/18	0.00	0.00	Packaging3-2		<i>llh</i>
140	QC21-SA	6 Ea		5/10/18	0.00	0.00	QC21		<i>llh</i>

Part Op 100 - Machine as per Folio FB458
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5380-1TRN	Support Turning Detail	3 Ea (.5 ea)	90-Start up Operation	

5069641

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5380-1TRN	3	0	0

Part Specifications

Specifications could not be found.



Container No: S071123



Part: D5380-1

Job No: 176805

Serial No/Batch: S071123

Revision: C

Inspector:

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 5/1/18 1:05 PM dart.lacelle.linda

Date: 05/14/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 176805
Description: Support		Part Number: D5380-1
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	3.890	3910		3.900	3.900			
AB	0.256	0.263		.258	.258			
AC	3.540	3.560		3.552	3.553			
AD	1.765	1.785		1.775	1.775			
AE	0.590	0.610		.596	.596			
AF	1.140	1.160		1.150	1.151			
AG	2.290	2.310		2.297	2.298			
AH	3.550	3.560		3.556	3.556			
AI	0.625	0.630		.6285	.628			
AJ	0.528	0.548		.537	.537			
AK	0.498	0.518		.500	.500			
AL	0.494	0.514		.495	.494			
AM	1.094	1.114		1.095	1.095			
AN	0.220	0.222		.220	.221			
AO	0.490	0.510		.500	.500			
AP	1.250	1.270		1.263	1.263			
AQ	2.465	2.485		2.475	2.475			
AR	1.405	1.425		1.413	1.411			
AS	0.050	0.110		.080	.080			
AT	0.300	0.360		.340	.340			
AU	0.100	0.125		.110	.111			
AV	0.220	0.280		R.250	R.250			
AW	0.030	0.090		R.060	R.060			
AX	0.010	0.030		R.020	R.020			
AY	0.115	0.135		R.125	R.125			
AZ	0.640	0.660		R.650	R.625			
Ensure that Ø " bore is perpendicular to " bore within "								
QTY 1				Accept/Reject	REJECT	Make	5/15/18	

Measured by: M.M.	Date:
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Audited by: A.E.	Date: 18-05-15
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	

Entered: **DAS 53** 9-89 Date: 5/16/18 MAY 25 2018



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 18-6874

Route update only ☐

Job: <u>176805</u> Part No. <u>D6380-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date: <u>5/18/2018</u>		Sequence #: <u>120</u>		QTY Affected: <u>(1)</u>		MRB (QSI042) <u>MKA 5/15/18</u>	
Description Work Order Deviation				Disposition		Completed By <u>5/15/18</u> <u>Maurice MKA</u>	
<u>the 0.625 dim is 0.633</u> <u>RC: the reamer broke inside the part</u>				<u>Ø 0.625 DIM IS Ø 0.6336</u> <u>PART IS SCRAP</u>		Lead hand / Supervisor <u>inf</u> <u>18/05/22</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☒ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up			
Other/Details:							